

Work Order ID 65759

January 25, 2011 7:46:54 AM



RUSH

Page 1

Item ID: D4151-3

Accept



Setup Start



Revision ID:

Item Name: Upper Hardpoint Plate

Stop



Start Date: 1/25/11 Start Qty: 10.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: U

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4151

C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 125

Cut as per dwg D4151

Prog Rev: E

Dwg Rev: E

Deburr as required

B11-1-26



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-1-26

Dart Aerospace Ltd

W/O: 65759		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/27	# 120	took qty x1 for QC inspection template	S	11/01/27	x1		S 11/01/27

Part No: D4151-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

January 25, 2011 7:46:46 AM

Page 1

Work Order ID: 65759

Parent Item: D4151-3

Parent Item Name: Upper Hardpoint Plate



Start Date: 1/25/11

Required Date: 1/26/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:ECI
IPP Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	65.2003	0.055	0.578947			



304/316 0.125 Sheet



1811-1-26

Location

Loc Qty

Loc Code

MAT

65.2003

114799

0.5003

116437

0.7

116623

64

114799

(12)

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DART AEROSPACE LTD		Work Order: 65759
Description: UPPER HARDPOINT PLATE		Part Number: D4151-3
Inspection Dwg: D4151-3, Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .252	+ .003 - .000	.252	✓		V HB02	
Ø .257	+ .006 - .001	.257	✓		V	
.375	± .010	.373	✓		V	
2.81	± .030	2.81	✓		V	
1.000	+ .003 - .001	1.001	✓		V	
1.83	± .030	1.824	✓		V	
.450	± .010	.451	✓		V	
.150	± .010	.150	✓		V	
.500	± .010	.500	✓		V	
1.100	± .010	1.100	✓		V	
1.250	± .010	1.250	✓		V	
3.460	± .010	3.458	✓		V	
3.97	± .030	3.97	✓		V	
.454	± .010	.453	✓		V	
1.99	± .020	1.983	✓		V	
1.000	± .010	1.001	✓		V	
.125	± .010	.116	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-1-07	Date: 11/2/27	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)

D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

RELEASED
2011-01-28

C	AN4 HARDWARE WAS AN3 (B8-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4151 TITLE BASKET FWD HARDPOINT SCALE NTS REV. C SHEET 1 OF 3 COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

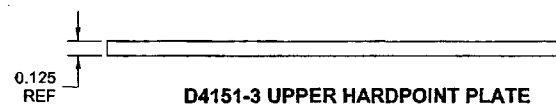
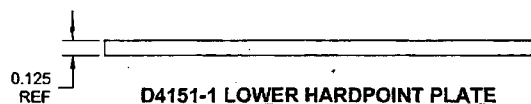
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DESIGN		
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MFG. APPR.		
APPROVED	AP	
DE APPR.		
DATE	10.12.14	

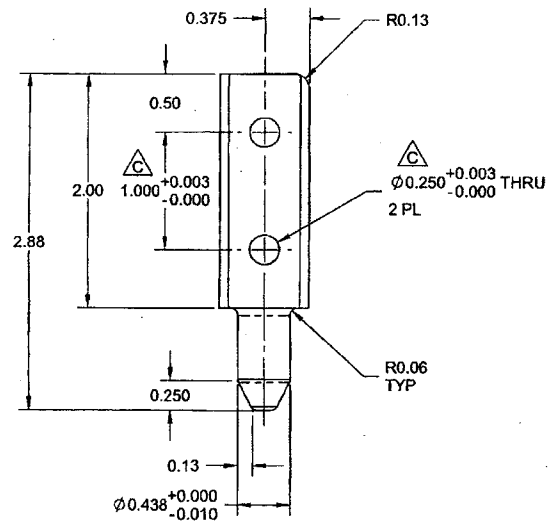
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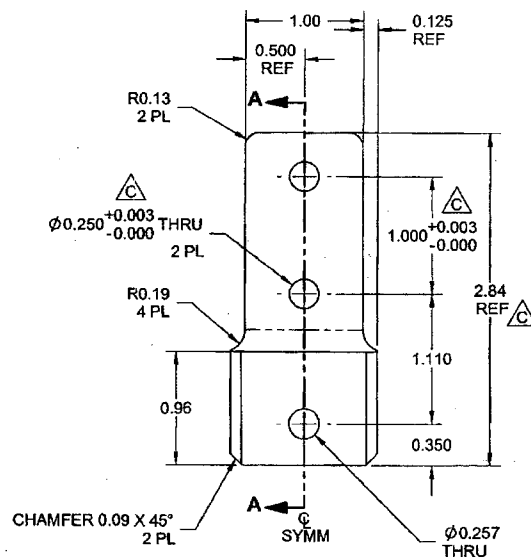
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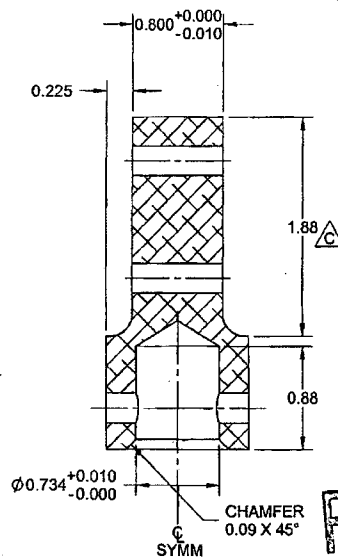
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)






D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN	15	DART AEROSPACE LTD	
DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
DATE	10.12.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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